

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023873**Date Inspected:** 19-May-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Kelly Leavitt, was present during the times noted above for random observations relative to the work being performed.

Trial Assembly

This QA Inspector observed the following work in progress for Trial Assembly.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Xie Ming Feng and ABF QA Sha Zhi.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components; OBG 13AW

PCMK: SEG3013AH

Weld No: 148

Welder: 067707

WPS-B-P-2214-B-U2-FCM-1

This QA Inspector observed the following work in progress for Trial Assembly.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Xie Ming Feng and ABF QA Sha Zhi.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

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Components; OBG 1CW
PCMK: SEG3015D
Weld No: 265
Welder: 045143
Weld Repair No. B-WR20929
WPS-345-FCAW-3G(3F)-ESAB-Repair-1

Components; OBG 13B/CW
PCMK: SEG3015L
Weld No: 091,096,106,116
Welder: 045240
Weld Repair No. B-WR21005
WPS-345-FCAW-3G(3F)-FMC-Repair-1

Components; OBG 13CW
PCMK: BP3065-001
Weld No: 049~060
Welder: 070101
WPS-B-T-3132-ESAB

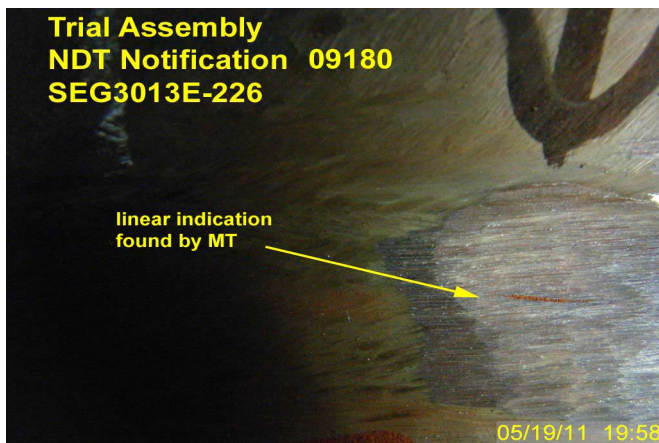
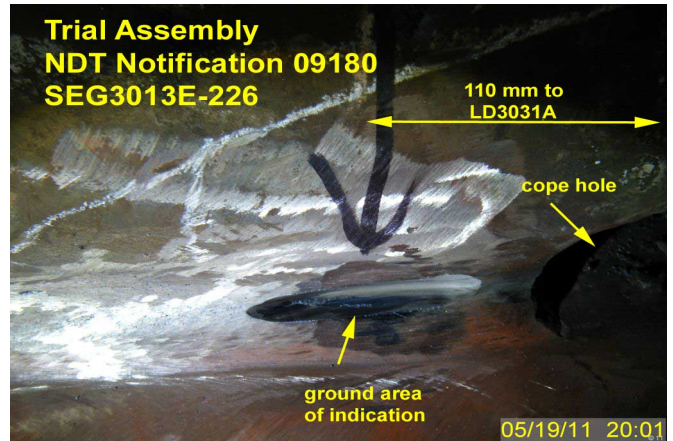
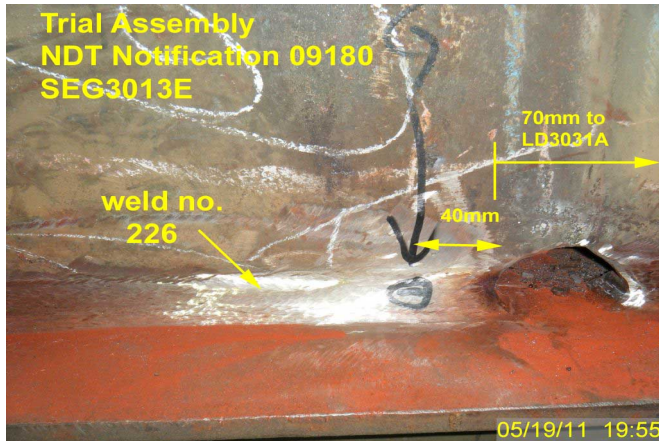
Components; OBG 13BW
PCMK: BP3062-001
Weld No: 001~012
Welder: 070101
WPS-B-T-3132-ESAB

This Quality Assurance (QA) Inspector, responding to NDT notification 09180, performed 100% Visual Inspection (VT) and approximately 15% Magnetic Particle Testing (MT) of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. The component OBG 13AW at SEG3013E weld number 226 was found to have an indication 14mm long, 110mm from LD3031A. This QA informed ZPMC QC Inspectors Sun Tian Liang, Hu Song Lin and AB Flour QA Inspector CK Chen of the problem. A TL-015 Incident Report, and a TL6028 MT report, will be documented for the accordance. (see photos)

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

"No relevant conversations."

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 1500026784, who represents the Office of Structural Materials for your project.

Inspected By: Leavitt,Kelly

Quality Assurance Inspector

Reviewed By: Riley,Ken

QA Reviewer